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ml
Airbus
11/13/18

D350-591-311
Job Sheet 182289



Part No: D350-591-311

Job Qty: 10 ea *9 cmf.*

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/21/18

Job Tracking No:

Due Date: 9/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	9/14/18	9/14/18	0.00	0.00	Start Up Large Fab-4		<i>CPL</i>
110	Large Fab	10 pcs	9/14/18	9/14/18	0.00	9.91	Large Fab 2		<i>ML</i>
120	QC	10 pcs	9/14/18	9/14/18	0.00	0.00	QC9		<i>ML</i>
130	QC	10 pcs	9/14/18	9/14/18	0.00	0.00	QC5		<i>ML</i>
140	HandFinish	10 pcs	9/14/18	9/14/18	0.00	1.84	HandFinish1		<i>D.R. 18-09/14</i>
150	QC	10 pcs	9/14/18	9/14/18	0.00	0.00	QC7-2		<i>38</i>
180	Large Fab	10 pcs	9/14/18	9/14/18	0.00	9.91	Large Fab 2		<i>DAS 38</i>
190	QC	10 pcs	9/14/18	9/14/18	0.00	0.00	QC10		<i>38</i>
200	QC	10 pcs	9/14/18	9/14/18	0.00	0.00	QC5		<i>38</i>
210	HandFinish	10 pcs	9/14/18	9/14/18	0.00	1.84	HandFinish1		<i>D.R. 18-09/20</i>
220	Powdercoat	10 pcs	9/14/18	9/14/18	0.00	2.90	Powdercoat1		<i>38</i>
230	HandFinish	10 pcs	9/14/18	9/14/18	0.00	1.84	HandFinish3		<i>38</i>
240	QC	10 pcs	9/14/18	9/14/18	0.00	0.00	QC3		<i>38</i>
250	Packaging	10 pcs	9/14/18	9/14/18	0.00	0.00	Packaging1-3		<i>69</i>
260	QC	10 pcs	9/14/18	9/14/18	0.00	0.00	QC4		<i>69</i>
270	Packaging	10 pcs	9/14/18	9/14/18	0.00	0.00	Packaging3-1		<i>69</i>
275	DC	10 pcs	9/14/18	9/14/18	0.00	0.00	DC		<i>69</i>
280	QC21-FG	10 Ea	9/14/18	9/14/18	0.00	0.00	QC21		<i>69</i>

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod *M134785* 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg

220 - START TIME: *11:00* OVEN TEMPERATURE: *300°* FINISH TIME: *12:00*

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

275 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 Ea (2 ea)	90-Start up Operation	<i>5104784</i>
D3219-1	Plate	20 Ea (2 ea)	90-Start up Operation	<i>5091413</i>
D3272-1	Step	10 Ea (1 ea)	90-Start up Operation	<i>5104784</i>

D3065-041	Step Leg Assembly	10 Ea (1 ea)	180-Large Fab
D3066-1	Spacer	20 Ea (2 ea)	180-Large Fab
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab
AN3-35A	Bolt	20 Ea (2 ea)	250-Packaging
AN4-13A	Bolt	80 Ea (8 ea)	250-Packaging
AN5-36A	Bolt	20 Ea (2 ea)	250-Packaging
D2230-3	Mounting Lug	40 Ea (4 ea)	250-Packaging
D2618	Bushing	20 Ea (2 ea)	250-Packaging
D2856-400-720	Abrasion Strip 4" X 7.20"	20 Ea (2 ea)	250-Packaging
D3235-1	Mounting Lug	20 Ea (2 ea)	250-Packaging
D3278-041	Support Assembly	10 Ea (1 ea)	250-Packaging
MS21042L3	Nut	20 Ea (2 ea)	250-Packaging
MS21042L4	Nut	80 Ea (8 ea)	250-Packaging
MS21042L5	Nut	20 Ea (2 ea)	250-Packaging
NAS1149D0363J	Washer	40 Ea (4 ea)	250-Packaging
NAS1149D0463J	Washer	160 Ea (16 ea)	250-Packaging
NAS1149D0563J	Washer	40 Ea (4 ea)	250-Packaging

5109745
 5168799
 5057529
 5084307
 5084302
 5094504
 5110581
 5089916
 5104552
 5113805
 5114310
 5094592
 5094592
 5093591
 5095293
 5089299
 5093773

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	20	153	0
	D3219-1	20	159	0
	D3272-1	10	0	0
180-Large Fab	D3065-041	10	48	0
	D3066-1	20	186	0
250-Packaging	MS20600-AD4W4	160	2,084	0
	AN3-35A	20	531	0
	AN4-13A	80	1,493	0
	AN5-36A	20	474	0
	D2230-3	40	87	0
	D2618	20	355	0
	D2856-400-720	20	198	0
	D3235-1	20	126	0
	D3278-041	10	28	0
	MS21042L3	20	3,922	0
	MS21042L4	80	5,582	0
	MS21042L5	20	1,066	0
	NAS1149D0363J	40	1,835	0
	NAS1149D0463J	160	9,537	0
	NAS1149D0563J	40	2,052	0

Part Specifications

Specifications could not be found.

Plex 8/21/18 1:43 PM Dart.lajeunesse.marie



Container No: S108689



Part: D350-591-311

Job No: 182289

Serial No/Batch: S108689

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-6 Issue 11, FAA STC SH967NE 04/12/21, BRAZIL 1

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Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Half-Access-Step™, Short Step - High Skid, LH
	X					D350-591-214	Half-Access-Step™, Short Step - High Skid, RH
		X				D350-591-215	Half-Access-Step™, Short Step - Low Skid, LH
			X			D350-591-216	Half-Access-Step™, Short Step - Low Skid, RH
				X		D350-591-311	Half-Access-Step™, Long Step - High Skid, LH
					X	D350-591-312	Half-Access-Step™, Long Step - High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2818	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2555-400-720	ABRASION STRIP
2	2	2	2	2	2	D3275-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN5-35A	BOLT
				5	8	AN6-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0553J	WASHER (AN980JD10)
12	12	12	12	16	16	NAS1149D0465J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

REFERENCE ONLY